



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBE105-15103W6**  
**Job Sheet 203708**



**Part No:** RBE105-15103W6

**Job Qty:** 2 pcs

**Part Name:** Main Rotor Blades Bonding Fixture



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 11/26/19

**Job Tracking No:**

**Due Date:** 1/24/20

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** IPP REV:A 17.11.07 NEW ISSUE DD VERF:DP

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 100   | Small Fab - 1               | 2 pcs | 1/24/20    |          | 0.00      | 0.50    | Small Fab - 1         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 8         |           |               |
|       |                             |       |            |          |           |         | Small Fab - 9         |           | GP 19-01-10   |
| 110   | QC 5                        | 2 pcs | 1/24/20    |          | 0.00      | 0.00    | QC 5 - 10             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |               |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |               |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 40             |           | 1 JAN 10 2020 |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |               |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |               |
| 120   | Packaging 3-1 - Stock - B4B | 2 pcs | 1/24/20    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |               |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |               |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |               |

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|     |            |       |         |                        |                 |
|-----|------------|-------|---------|------------------------|-----------------|
|     |            |       |         | Packaging 3 - 4 - B4B  |                 |
|     |            |       |         | Packaging 3 - 5 - B4B  |                 |
|     |            |       |         | Packaging 3 - 6 - B4B  |                 |
|     |            |       |         | Packaging 3 - 7 - B4B  | DAS             |
|     |            |       |         | Packaging 3 - 8 - B4B  | 28              |
|     |            |       |         | Packaging 3 - 9 - B4B  | 9-89            |
|     |            |       |         | Packaging 3 - 10 - B4B |                 |
|     |            |       |         | Packaging 3 - 11 - B4B |                 |
|     |            |       |         | Packaging 3 - 12 - B4B |                 |
|     |            |       |         | Packaging 3 - 13 - B4B |                 |
|     |            |       |         | Packaging 3 - 14 - B4B |                 |
|     |            |       |         | Packaging 3 - 15 - B4B |                 |
|     |            |       |         | Packaging 3 - 16 - B4B |                 |
|     |            |       |         | Packaging 3 - 17 - B4B |                 |
|     |            |       |         | Packaging 3 - 18 - B4B |                 |
|     |            |       |         | Packaging 3 - 19 - B4B |                 |
|     |            |       |         | Packaging 3 - 20 - B4B |                 |
|     |            |       |         | Packaging 3 - 21 - B4B |                 |
|     |            |       |         | Packaging 3 - 22 - B4B |                 |
|     |            |       |         | Packaging 3 - 23 - B4B |                 |
|     |            |       |         | Packaging 3 - 24 - B4B |                 |
|     |            |       |         | Packaging 3 - 25 - B4B |                 |
|     |            |       |         | Packaging 3 - 26 - B4B |                 |
|     |            |       |         | Packaging 3 - 27 - B4B |                 |
|     |            |       |         | Packaging 3 - 28 - B4B |                 |
|     |            |       |         | Packaging 3 - 29 - B4B |                 |
|     |            |       |         | Packaging 3 - 30 - B4B |                 |
|     |            |       |         | Packaging 3 - 31 - B4B |                 |
|     |            |       |         | Packaging 3 - 32 - B4B |                 |
|     |            |       |         | Packaging 3 - 33 - B4B |                 |
|     |            |       |         | Packaging 3 - 34 - B4B |                 |
|     |            |       |         | Packaging 3 - 35 - B4B |                 |
|     |            |       |         | Packaging 3 - 36 - B4B | DAS             |
| 130 | QC 21 - SA | 2 pcs | 1/24/20 | 0.00 0.00              | QC 21 - SA - 21 |
|     |            |       |         |                        | QC 21 - SA - 70 |
|     |            |       |         |                        | QC 21 - SA - 53 |

Part Op 100 - (Small Fab) ASSEMBLE AS PER DWG

Descriptions: 110 - (QC5- inspect part completeness to step on W/O)

120 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

130 - (QC21- Final Inspection - Work Order Release)

GA159

## Job BOM

| Part / Item      | Component Name                   | Quantity     | Operation         | Container |
|------------------|----------------------------------|--------------|-------------------|-----------|
| 91595A392        | Dowel Pin ØM5 x 50mm Alloy Steel | 2 Ea (1 ea)  | 100-Small Fab - 1 | 5180881   |
| RBE105-15103W6-1 | Bonding Fixture Knob             | 2 pcs (1 ea) | 100-Small Fab - 1 | 5236365   |
| RBE105-15103W6-2 | Bonding Fixture Shaft            | 2 pcs (1 ea) | 100-Small Fab - 1 | 239703    |
| RBE105-15103W6-3 | Bonding Fixture Bushing          | 4 pcs (2 ea) | 100-Small Fab - 1 | 237678    |
| RBE105-15103W6-4 | Bonding Fixture Handle Knob      | 2 pcs (1 ea) | 100-Small Fab - 1 | 236388    |

## Job Allocations

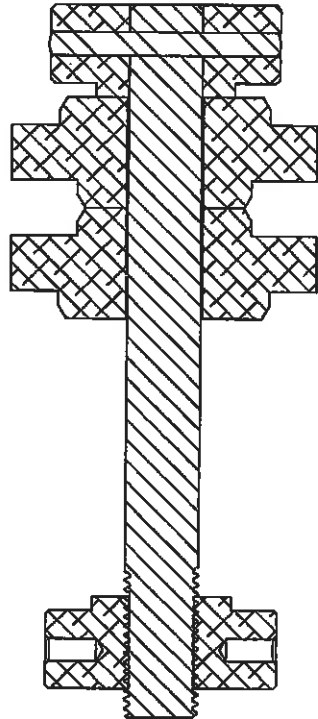
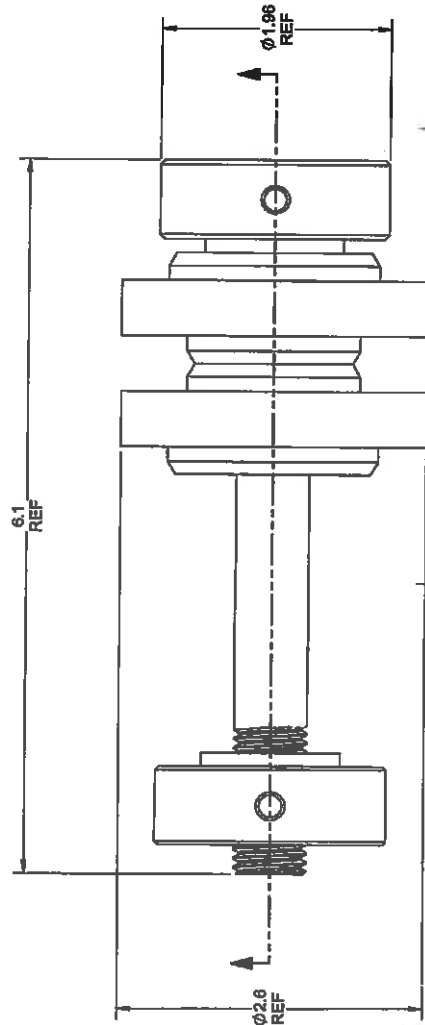
| Operation         | Component Part   | Required | Inventory | Allocated |
|-------------------|------------------|----------|-----------|-----------|
| 100-Small Fab - 1 | 91595A392        | 2        | 10        | 0         |
|                   | RBE105-15103W6-1 | 2        | 0         | 0         |
|                   | RBE105-15103W6-2 | 2        | 0         | 0         |
|                   | RBE105-15103W6-3 | 4        | 0         | 0         |
|                   | RBE105-15103W6-4 | 2        | 0         | 0         |

|                                    |
|------------------------------------|
| <b>Part Specifications</b>         |
| Specifications could not be found. |

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| ITEM NO. | QTY | Part #                  | Description                   | PG. |
|----------|-----|-------------------------|-------------------------------|-----|
| -1       | 1   | RBE105-15103W6-1        | BONDING FIXTURE KNOB          | 2   |
| -2       | 1   | RBE105-15103W6-2        | BONDING FIXTURE SHAFT         | 3   |
| -3       | 2   | RBE105-15103W6-3        | BONDING FIXTURE BUSHING       | 4   |
| -4       | 1   | RBE105-15103W6-4        | BONDING FIXTURE HANDLE KNOB   | 5   |
| 5        | 1   | McMaster-Carr 91588A392 | M5x50mm ALLOY STEEL DOWEL PIN | -   |

| REV. | DESCRIPTION | DATE       | BY  | APPROVED |
|------|-------------|------------|-----|----------|
| A    | NEW ISSUE   | 28/07/2017 | SAC | WM       |



SECTION VIEW

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 203708M5  
19-11-26

**DART**  
AIRCRAFT COMPONENTS  
Hamilton, Ontario, Canada

**MAIN ROTOR BLADES BONDING FIXTURE**

Part No. RBE105-15103W6 Rev. A

Customer Part: SAC 21062017  
Customer Qty: 1  
Customer Unit: 1  
Customer Material: 1  
Customer Finish: 1  
Customer Spec: 1  
Customer Break: 1  
Customer Identification: 1  
Customer Ref: 1

Approved: [Signature]  
Date: 02/12/17  
Scale: 1:1

Sheet 1 of 6

**RBE105-15103W6 MAIN ROTOR BLADES BONDING FIXTURE**

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) SPEC: N/A
  - 5) BREAK ALL SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) REF AIRBUS TIN: 105-15103W6

EN 17-68

Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

**NCR No.**

Route update only

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |              |  |                     |  |  |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------|--|---------------------|--|--|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | <b>DEPARTMENT/PROCESS</b><br><br><div>             Skid-tube <input type="checkbox"/>    Cross tube <input type="checkbox"/>    Eng. (Non-AW) <input type="checkbox"/>    Engineering <input type="checkbox"/><br/>             Machining <input type="checkbox"/>    Small Fab <input type="checkbox"/>    Prod. Eng. Coord. <input type="checkbox"/>    Water Jet <input type="checkbox"/><br/>             Large Fab <input type="checkbox"/>    Finishing <input type="checkbox"/>    Rec/Store/Packaging <input type="checkbox"/>    Supplier <input type="checkbox"/><br/>             Quality <input type="checkbox"/> </div> |  |              |  |                     |  |  |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | Sequence #: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | MRB (QS1042) |  |                     |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |              |  |                     |  |  |  |
| Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |              |  |                     |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |              |  | QC / QA Coordinator |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |              |  |                     |  |  |  |
| <b>Root Cause</b><br><br><div>             Operator <input type="checkbox"/><br/>             Manufacturing Process <input type="checkbox"/><br/>             Equip/Tooling <input type="checkbox"/><br/>             Handling/Preservation <input type="checkbox"/><br/>             Material <input type="checkbox"/><br/>             Product Improvement <input type="checkbox"/><br/>             Process Improvement <input type="checkbox"/><br/>             Human Factors <input type="checkbox"/> </div> |  | <b>FAULT CATEGORY</b><br><br><div> <div>             Contamination <input type="checkbox"/><br/>             Misaligned/off center <input type="checkbox"/><br/>             BOM/Route <input type="checkbox"/><br/>             Broken/Damage/Defect <input type="checkbox"/><br/>             Incomplete/Unclear Instructions <input type="checkbox"/><br/>             Drill Holes <input type="checkbox"/><br/>             Fit/Function <input type="checkbox"/> </div> <div>             Pressure/Forced <input type="checkbox"/><br/>             Bending <input type="checkbox"/><br/>             Crushing <input type="checkbox"/><br/>             Cracks <input type="checkbox"/><br/>             Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br/>             Marks/Chatter <input type="checkbox"/><br/>             Mislabeled <input type="checkbox"/> </div> <div>             Power Loss/Surge <input type="checkbox"/><br/>             Folio/Program <input type="checkbox"/><br/>             Grain Direction <input type="checkbox"/><br/>             Weld <input type="checkbox"/><br/>             Wrong Stock Pulled <input type="checkbox"/><br/>             Out of Sequence <input type="checkbox"/><br/>             Off-set/Set-up <input type="checkbox"/> </div> </div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |              |  |                     |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |              |  |                     |  |  |  |